

Work Order ID **76483**

**\*76483\***

Page 1

Tuesday, November 15, 2011 1:57:37 PM

Item ID: D4108-7

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket

Start Date: 11/15/2011 Start Qty: 4.00 **\*4\***

Cust Item ID:

Required Date: 11/22/2011 Req'd Qty: 4.00 **\*4\***

Customer:

Reference:

Approvals: Process Plan:                      Date: 11-11-15 Tooling:                      Date:                       
QC:                      Date:                      SPC (Y/N):                      Date:                     

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4108	<u>                    </u>

100 Cut blanks as per folio

**\*100\***  
Bandsaw  
Jeaspa Bandsaw

Memo

110  
**\*110\***  
HAAS 1                       
HAAS CNC vertical machine #1

Memo  
MILL AS PER DWG AND FOLIO FA977  
FOLIO REV:                       
DWG REV:                     

DEBURR

issue P/O to Archer.  
Machine as per dwg D4108 rev. A

                     11/12/13

                     CZ 11/12/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Work Order ID 76483

\*76483\*

Page 2

Tuesday, November 15, 2011 1:57:37 PM

Item ID: D4108-7 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Bracket  
Start Date: 11/15/2011 Start Qty: 4.00 \*4\* Cust Item ID:  
Required Date: 11/22/2011 Req'd Qty: 4.00 \*4\* Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*  
Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 *read*  
\*120\*  
QC  
Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

*read + inspect for tension damage  
attached CQC to W/O*

130 QC Inspect parts - second check

0.00

\*130\*

QC

Memo

0.00

Quality Control

135 *chemical Conversion Coat*  
136 *QC-7*

0.00

140

Identify as per dwg & Stock Location *128*

0.00

\*140\*

Packaging

Memo

Packaging

*11/22/28 (7)*

*(47)*

*7/7/6/12-2-29*

*11/12/10/9 (17)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
12/01/29	#131	chemical coat Alodine as per Q57005					S 12/01/29	
	#132	QC 7 inspect alodine as per Q57005					S 12/01/29	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 76483****\*76483\***

Page 3

Tuesday, November 15, 2011 1:57:37 PM

Item ID: D4108-7

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket

Start Date: 11/15/2011 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 11/22/2011 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC21- Final Inspection - Work Order Release

0.00

**\*150\***

QC

Memo

0.00

Quality Control

MLJ 12/03/01

MLJ 12/03/01  
7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Tuesday, November 15, 2011 1:57:43 PM

Work Order ID: 76483

\*76483\*

Parent Item: D4108-7

\*D4108-7\*

Parent Item Name: Bracket

Start Date: 11/15/2011

Required Date: 11/22/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-10-15 JLM VERIFIED BY:DD IPP  
Rev:B 10.12.03 as per dwg rev.B DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B2.000X02.00  
0

Purchased

No

100

f

8.3100

0.2

0.842105

\*M6061T6B2-000X02-000\*

\*\*

6061-T6 Bar 2:00-x2.00

Location

Loc Qty

Loc Code

MAT009

8.31

113123

7.12

13085

1.19

m119513

1.3f \* 11/12/13

8.42105 x 10

D4108-7P

X6

R12/12/13 (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

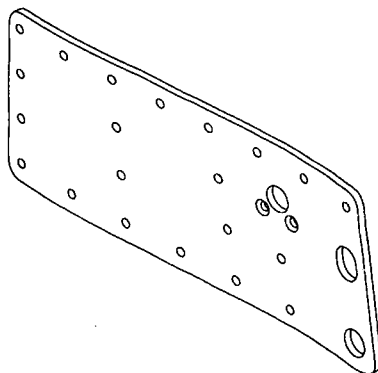
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

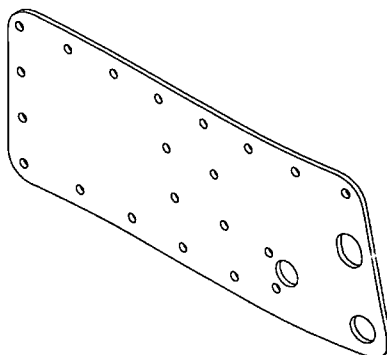
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

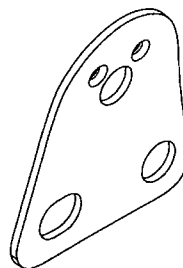




**D4108-1 LEFT PASS DOOR DOUBLER**



**D4108-3 RIGHT PASS DOOR DOUBLER**

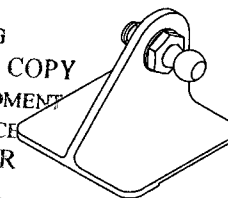


**D4108-5 SMALL RIGHT DOOR DOUBLER**

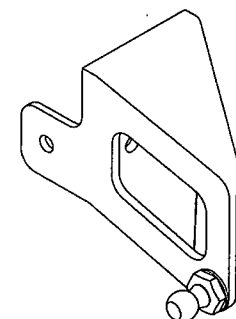


**D4108-11 TEMPLATE**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70483



**D4108-047 SILL BRACKET ASSEMBLY**



**D4108-049 LITTER DOOR FITTING ASSEMBLY**

**RELEASED**  
2010-11-30

B	D4108-5 (ZN C4-1 & B4-4) VIEWS UPDATED. D4108-7/-9 MTL CHANGED TO 6061-T6 AL. NOTES UPDATED (SHT 5,8)	JPH	10.11.01
A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D4108	SHEET 1 OF 7
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	DOUBLERS & FITTINGS	NTS
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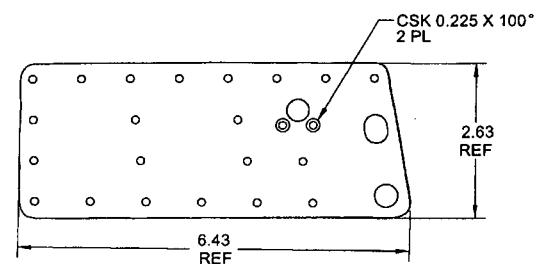
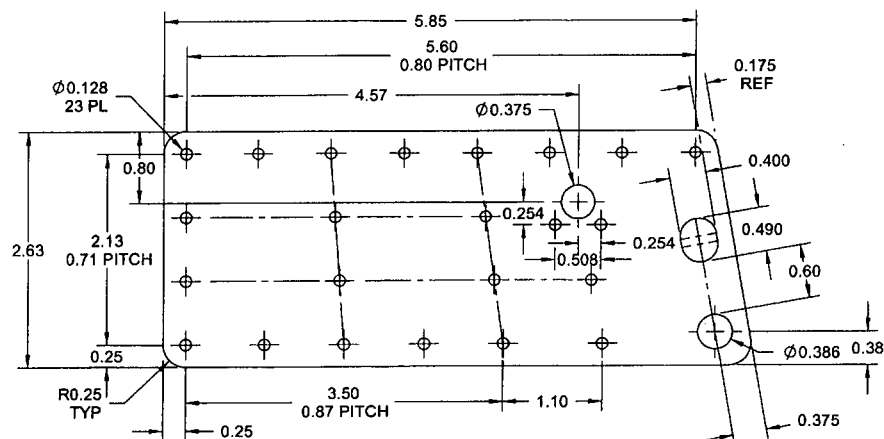
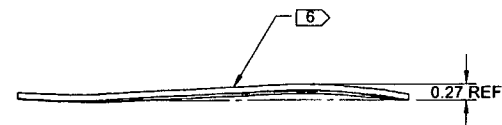
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4108-1F FLAT PATTERN, LEFT PASSENGER DOOR DOUBLER**

NOTES:  
1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M304S16GA OR M303S16GA  
-1 : MAKE FROM D4108-1F.

- 2) FINISH: NONE.  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.  
4) UNITS: INCHES UNLESS OTHERWISE NOTED.  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: -1: P/N D4108-1 & B/N PER QSI 044 6.1  
7) WEIGHT: 0.29 lbs  
8) FORM & INSPECTION PER TEMPLATE DT9648.

RELEASED  
2010-11-30  
wp

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. 1
MFG. APPR.	<i>[Signature]</i>	D4108	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALES
DE APPR.	<i>[Signature]</i>	<b>DOUBLERS &amp; FITTINGS</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

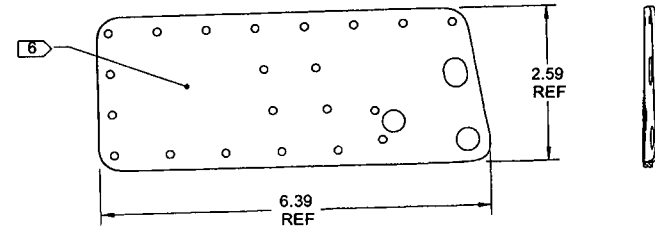
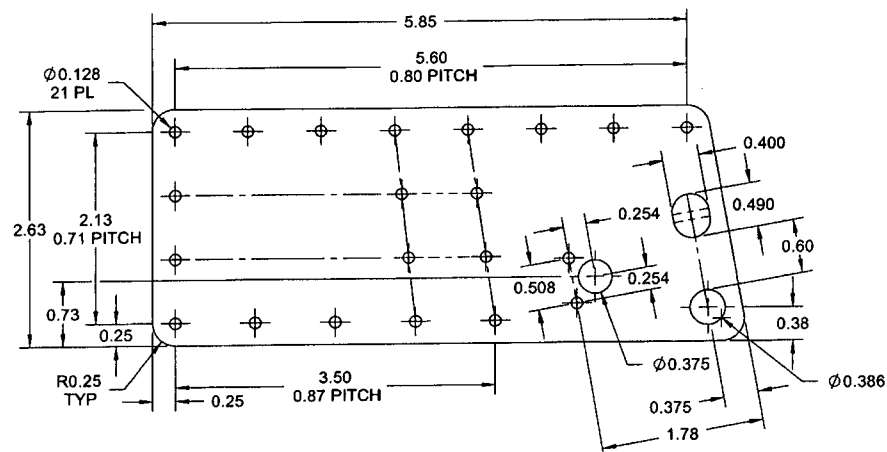
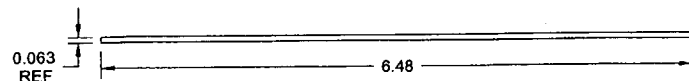
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

76483



**D4108-3 RIGHT PASS DOOR DOUBLER (8)**  
(MAKE FROM D4108-3F)

**D4108-3F FLAT PATTERN, RIGHT PASSENGER DOOR DOUBLER**

- NOTES:
- 1) MATERIAL -3F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M304S16GA OR M303S16GA  
-3 : MAKE FROM D4108-3F.
  - 2) FINISH: NONE.
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: -3: P/N D4108-3 & B/N PER QSI 044 6.1
  - 7) WEIGHT: 0.29 lbs
  - 8) FORM & INSPECTION PER TEMPLATE DT9649-

RELEASED  
2010-11-30  
NB

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D4108	SHEET 3 OF 7
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	DOUBLERS & FITTINGS	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

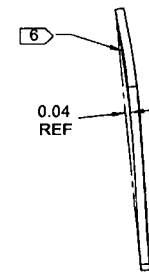
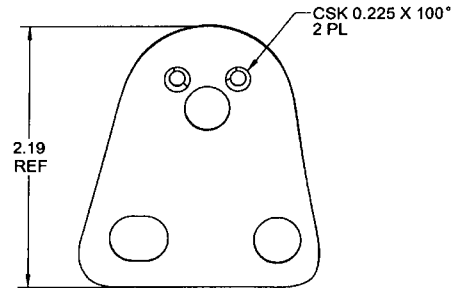
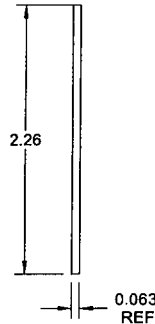
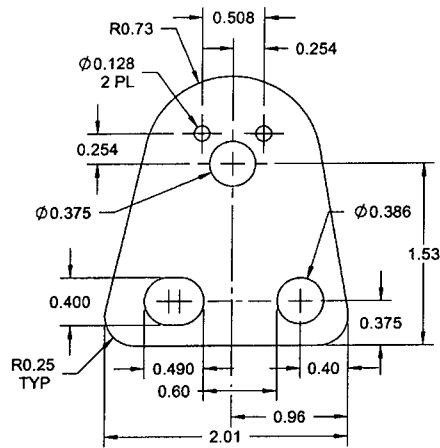
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

76483







**D4108-5F FLAT PATTERN, SMALL RIGHT DOOR DOUBLER**

**D4108-5 SMALL RIGHT DOOR DOUBLER  
(MAKE FROM D4108-5F)**

**NOTES:**

- 1) MATERIAL -5F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M304S16GA OR M303S16GA  
-5: MAKE FROM D4108-5F.
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: -5: P/N D4108-5 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.06 lbs
- 8) FORM & INSPECT PER TEMPLATE DT9649.

RELEASED  
2010-11-30  
ND

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4108	SHEET 4 OF 7
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

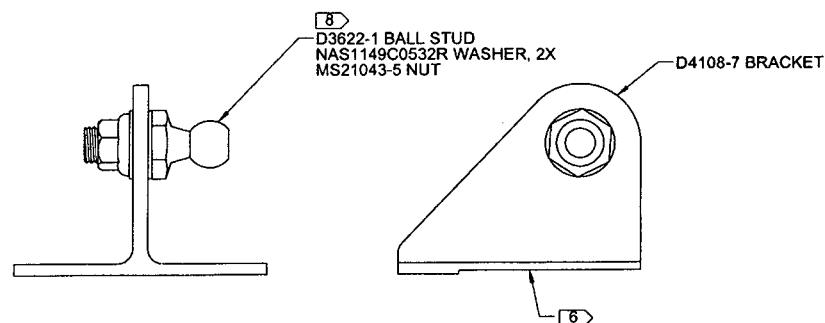
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

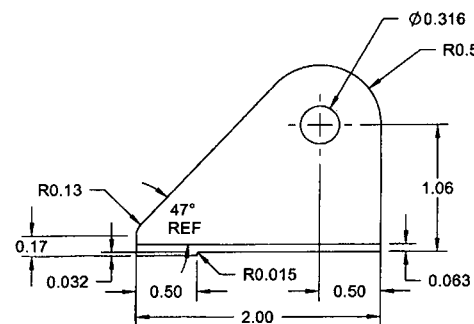
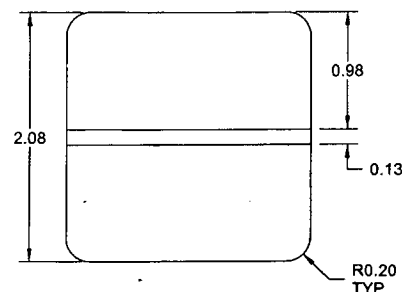
**NOTE:** Date & initial all entries



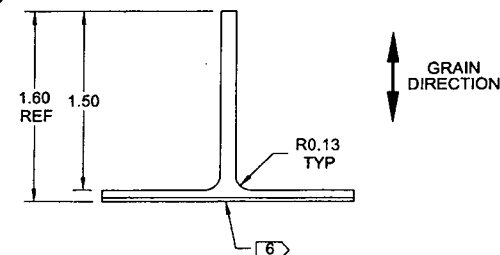
Qty	Part Number	Description
-047	D4108-047	SILL BRACKET ASSEMBLY
1	D4108-7	BRACKET
1	D3622-1	BALL STUD
1	MS21043-5	NUT
2	NAS1149C0532R	WASHER







**D4108-047 SILL BRACKET ASSEMBLY**



**D4108-7 BRACKET**



- NOTES:**
- 1) MATERIAL -7: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1.
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: P/N D4108-X & B/N PER QSI 044 6.1
  - 7) WEIGHT -047: 0.10 lbs
  - 8) TORQUE TO 5-10 INCH POUND.

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4108	SHEET 5 OF 7
APPROVED		TITLE	SCALE
DE APPR.		DOUBLERS & FITTINGS	NTS
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RELEASED  
2010-11-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

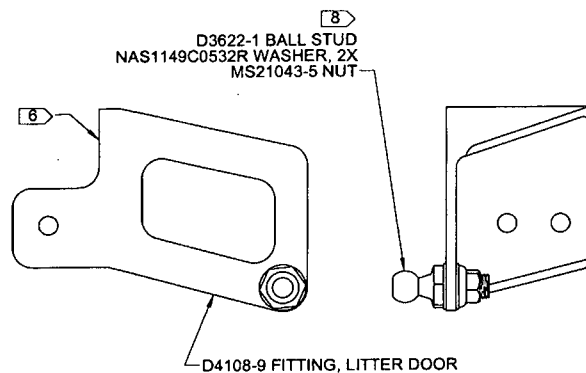
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

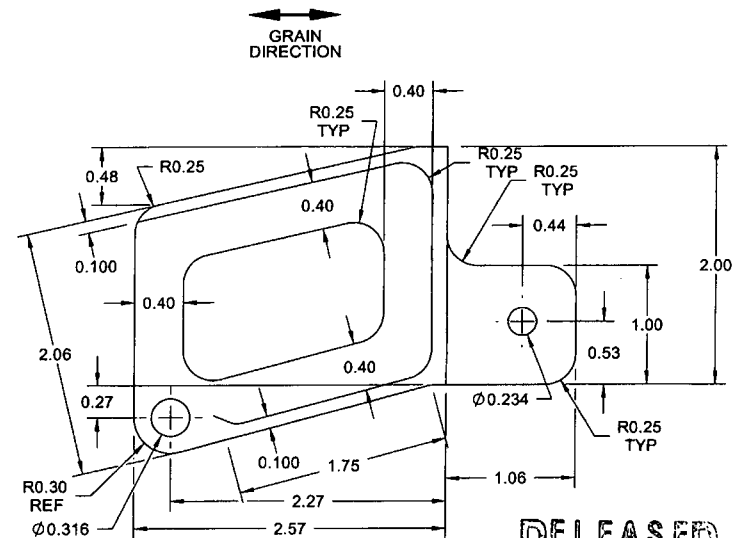
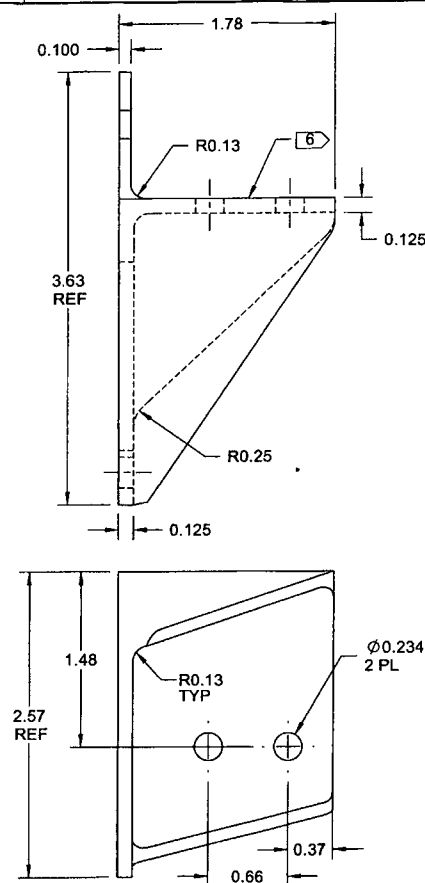
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Qty -049	Part Number	Description
1	D4108-049	LITTER DOOR FITTING ASSEMBLY
1	D4108-9	FITTING, LITTER DOOR
1	D3622-1	BALL STUD
1	MS21043-5	NUT
2	NAS1149C0532R	WASHER



**D4108-049 LITTER DOOR FITTING ASSEMBLY**



**D4108-9 FITTING, LITTER DOOR**

- NOTES:**
- 1) MATERIAL -9: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: P/N D4108-X & B/N PER QSI 044 6.1
  - 7) WEIGHT -049: 0.19 lbs
  - 8) TORQUE TO 15 INCH POUND.

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4108</b>	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE <b>DOUBLERS &amp; FITTINGS</b>	SHEET 6 OF 7
APPROVED	<i>[Signature]</i>	SCALE NTS	
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.11.01		

RELEASED  
2010-11-30

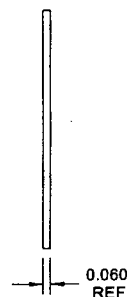
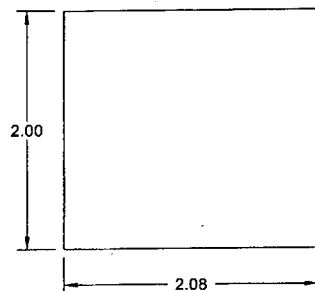
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4108-11 TEMPLATE**

**NOTES:**

- 1) MATERIAL: LEXAN 9034 SHEET, 0.060 THK  
REF DART MLEXS.060-9034-08  
OR POLYCAST II CLEAR ACRYLIC, .060 THICK.  
REF DART M-ACRYLIC-S.060
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N D4108-11 PER QSI 044 6.1
- 7) WEIGHT: N/A

**RELEASED**  
2010-11-30

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4108	SHEET 7 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLERS & FITTINGS	NTS
DATE	10.11.01	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



1393 Major Road  
Orleans, ON  
K1E 1H3

Phone # 613-899-2405

# Packing Slip

Date	Invoice #
2/24/2012	60

Ship To
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
15679	2/24/2012	FedEx	Archer	

Qty	Item Code	Description
7	Sales	D4108-7P Bracket Line Item 3 on your PO 15679 HST (ON) on sales



1393 Major Road  
Orleans, Ontario  
K1E 1H3

Telephone (613) 899-2405  
Fax (613) 226-1719

## Certificate of Compliance

To:  
Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury Ont.  
K6A 1K7

*Sr/ktg*

Po Number	Part Number	Quantities
15679	D4108-7	7

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 15679 issued by Dart Aerospace Inc.

A handwritten signature in black ink, appearing to read "Alex Mazerolle", is written over a horizontal line.

Alex Mazerolle  
President  
Archer Precision Inc.  
1393 Major Road,  
Orleans Ontario  
K1E 1H3



# Inspection Report

Customer Name <b>Dart Aerospace</b>			QTY <b>1</b>	DWG # <b>D4108</b>	REV. <b>B</b>	Part Name <b>Doublers and Fittings</b>		Date <b>Feb. 24/2012</b>	Lot#	Job # <b>477-3</b>
Page 1 of		Inspection Interval	Special Notes							

Item #	DWG. Dim	Tolerance	Operator First Off	QA First Off		QA Final		2		3		4		5		6		7		8		9	
				A	R	A	R																
	Rev	B	B	✓		✓																	
	MAT	Supplied	✓	✓		✓																	
	SUB	None	NONE	✓		✓																	
	Deburr	Yes	yes	✓		✓																	
1	2.08	+/- .030	2.082	✓		✓		2.201	2.201	2.201	2.201	2.201	2.201	2.201	2.201								
2	0.98	+/- .030	0.977	✓		✓																	
3	0.13	+/- .030	0.127	✓		✓		0.127	0.125	0.126	0.125	0.126	0.126	0.126	0.126								
4	0.20	+/- .030	.201	✓		✓																	
5	0.316	+/- .010	0.318	✓		✓		0.318	0.318	0.318	0.318	0.318	0.318	0.318	0.318								
6	0.5	+/- .030	0.500	✓		✓																	
7	1.06	+/- .030	1.065	✓		✓																	
8	.063	+/- .010	0.064	✓		✓		0.064	0.064	0.064	0.064	0.064	0.064	0.064	0.064								
9	0.50	+/- .030	0.504	✓		✓																	
10	2.00	+/- .030	1.997	✓		✓		STOCK		SIZE													
11	0.15	+/- .030	0.015	✓		✓																	
12	0.50	+/- .030	0.510	✓		✓																	
13	0.032	+/- .010	0.033	✓		✓																	
14	0.17	+/- .030	PP	✓		✓																	
15	0.13	+/- .030	PP	✓		✓																	
16	47 Deg	Ref	46.95°	✓		✓																	
17	1.60	Ref	1.595	✓		✓																	
18	1.50	+/- .030	1.500	✓		✓																	
19	0.13	+/- .030	PP	✓		✓																	